

Tap M8 Ø8.1, Z4, Helix 0°

A10-020



Tool
The 4 fluted Tap M8 with straight flute is ground from solid cylindrical blank between centers. A special clamping acts as dog and drive system on the square at the shafts end. Flutewheel and threading Formwheel are dressed in the cicle.

Blank
Dimension: Ø 8.15/ Ø 6.2/ Ø 8 mm, L 90mm
HSS

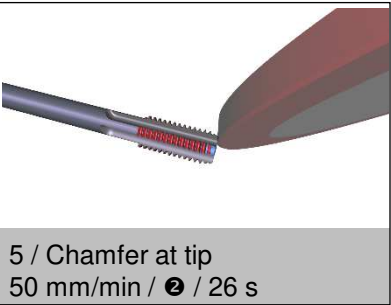
N° / Process description
Feed rate / Wheel / Time

1 / Plungedress Threadwheel
0.4 mm/min / ③ / 20 s

1 / Flute
2200 mm/min / ① / 86 s

3 / Thread
50 mm/min / ③ / 48 s

4 / Chamfer
50 mm/min / ② / 22 s



5 / Chamfer at tip
50 mm/min / ② / 26 s

Total cycle time: 3 Min 22 s

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

SCHNEEBERGER

Machine / Configuration

- Machine: Gemini NGM TAP Robot
- Control: Fanuc 31iB
- Accessories: 2 Dressing Units, Tailstock for Taps,

Wheels / Wheel packs

